

Date: Thursday, 12/13/2007 2:39:01 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PLUG		
Job Number	: 36327		Part Number	: D25941		
Estimate Number	: 10178		Drawing Number	: D2594 REV C		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	12/13/2007	S.O. No.	: N/A		Drawing Revision	: C
Prsht Rev.	: NC		Type	: MACHINED PARTS		
First Issue	: N/A		Material	: N/A		
Previous Run	: 35919		Due Date	: 1/24/2008		
Written By	:		Qty:	500	Um:	Each
Checked & Approved By	:		Handwritten signature: 07.12.13			
Comment	Est D 02.08.22 Make in Cobra KJ est E 06.12.11 ecn 836 EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0625	6061-T6 Round Bar .625"	
Comment: Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s) Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625). Batch M106104 H.A 07/12/19			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
Comment: HARDINGE CNC LATHE SMALL 1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max. H.A/ML 07/12/19 RD 07/12/19			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE RD 07/12/21 H.A/ML 07/12/19			
4.0	QC8	SECOND CHECK	
Comment: SECOND CHECK ML 07.12.22 598			
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1 BL 08-01-04 542			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/01/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



*M 106379*



*542*

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*M 106379*

*08/01/08*



*542X*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



*542X*

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*F-P-1*

*M 1*

*08/01/08*

9.0 QC21

FINAL INSPECTION/W/O RELEASE



*542*

Comment: FINAL INSPECTION/W/O RELEASE

*M 106379*

Job Completion



*20081118*

*U*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36327
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594	Rev: C	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

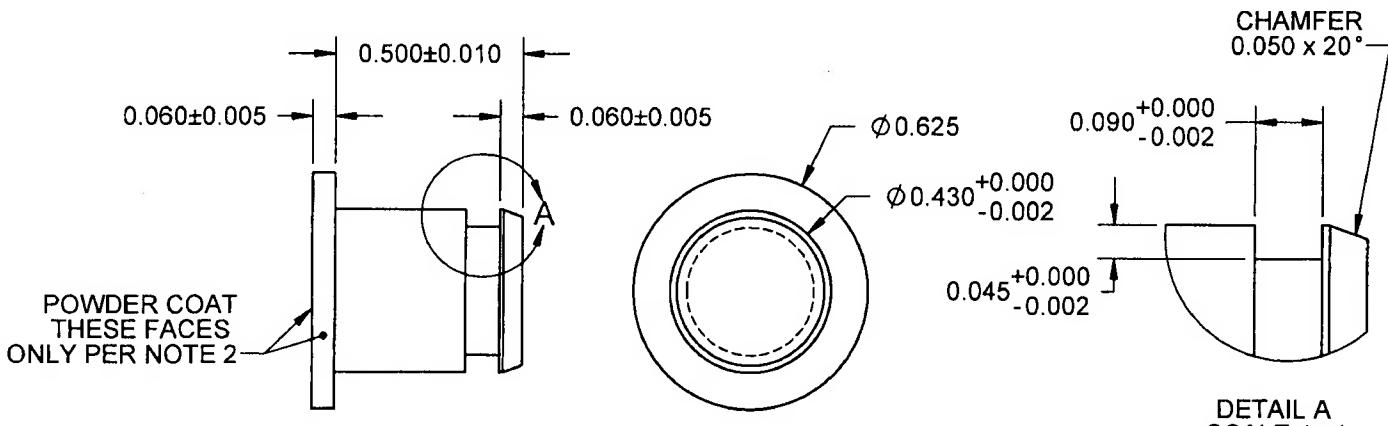
Measured by: <u>H.A. Pml</u>	Audited by: <u>ZG</u>	Prototype Approval: N/A
Date: <u>07/12/19</u>	Date: <u>07/12/19</u>	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.12.20	Dwg Rev. updated	KJ/JLM	<i>[Signature]</i>

**DART**

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D2594	REV. C	SHEET 1 OF 1
DATE 06.11.20		TITLE PLUG	SCALE	2:1

REV	DATE	DESCRIPTION
A	96.09.16	NEW ISSUE
B	97.03.15	ADD GROOVE AND O-RING
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE



**D2594-1 PLUG**

**D2594-1 PLUG NOTES:**

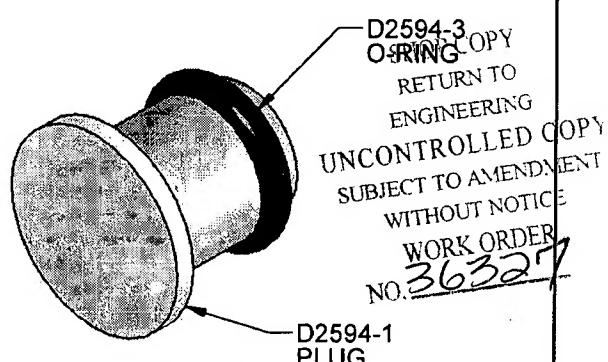
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3  $\triangle$
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

**D2594-3 O-RING NOTES:**

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011  $\triangle$

**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



**D2594 PLUG ASSEMBLY**

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